

Date: Thursday, 8/23/2007 11:50:32 AM
 User: Kim Johnston

Process Sheet

SP/17 1

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 34220	
Estimate Number : 12403	
P.O. Number :	Part Number : D3511041
This Issue : 8/23/2007 S.O. No. :	Drawing Number : D3511 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 11 Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 32808	Material :
Written By :	Due Date : 9/20/2007 Qty: 11 Um: Each
Checked & Approved By : <u>AD 07.08.23</u>	
Comment : Est Rev:A New Issue 06-05-04 JLM	
Est Rev:B New process 06-05-05 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S188	304 SHEET .188" THICK
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Comment: Qty.: - 1.5572 sf(s)/Unit Total : 15.5715 sf(s)

304 SHEET .188" THICK

(M304S0188)

Batch: M104699

SAD 07/08/26

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3511

Dwg Rev: AProg Rev: A

2-Deburr if necessary

Identify as D3511-1

SAD 07/08/26

(61)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/08/26

11

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SAD 07/09/13 (416)

counter

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 34220

Part Number: D3511041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D35031

CUP



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

CUP

Batch: B28277

FC 07/10/10 (4)

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bend fwd 90 deg. bend per dwg D3511

SB 07/09/10 (10)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En plod 19 (4) cuts

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3511

A/R SS ROD Batch: M104721

FC 07/10/10 (4)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form as per Dwg D3511

SB 07/10/15 (4)

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-10-15 (4)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/10/15 (4) cuts

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M- 07/10/15 (4X)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 34220

Part Number: D3511041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten signature and date 07/10/16

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Handwritten signature and date 07/10/16

15.0

QC21

FINAL INSPECTION/W/O RELEASE



07.10.16

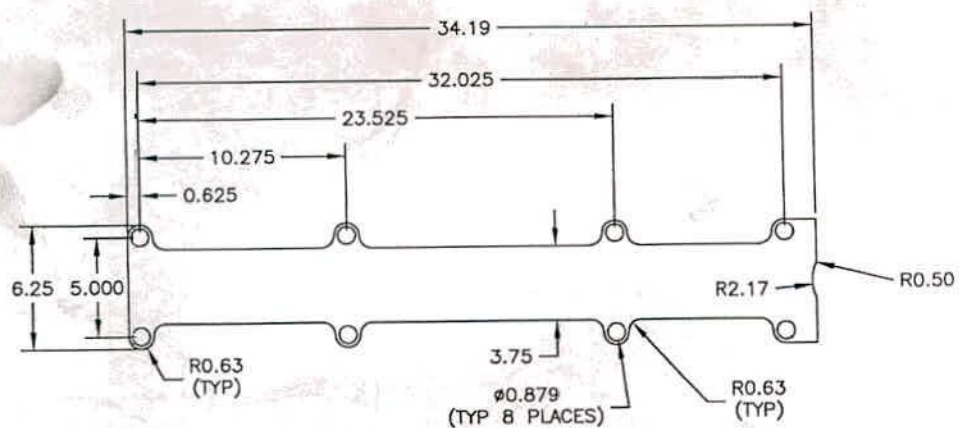
Handwritten mark

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

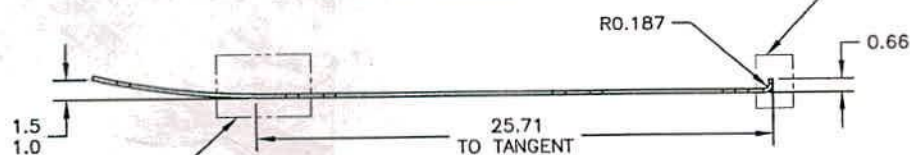


u 07-10-16



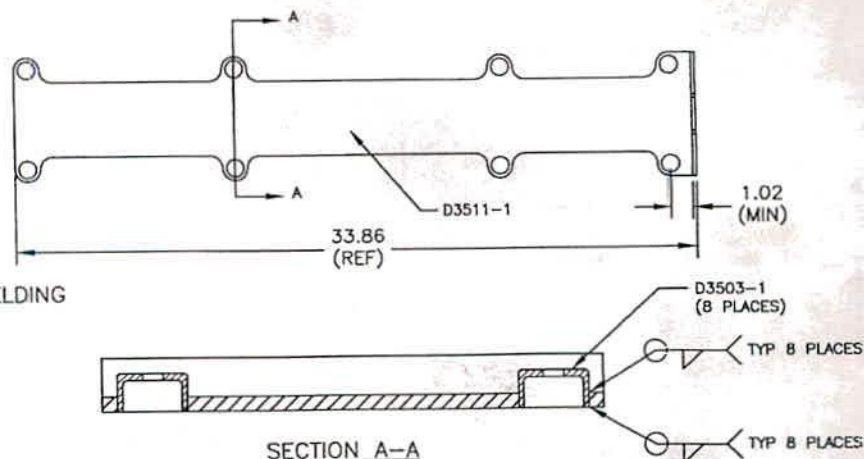
D3511-1F FLAT PATTERN

NOTE: BEND BEFORE WELDING



D3511-1 BEND DETAIL

NOTE: BEND AFTER WELDING



D3511-041 WELD DETAIL

D3511-041 WEARPLATE ASSEMBLY

- 1) MAKE D3511-1F WEARPLATE FROM: AISI 304/316 STAINLESS STEEL (0.188 THICK)
(REF DART MATERIAL SPEC. M304S7GA)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ASSEMBLY BLACK SANDEX (REF. 4.3.5.7) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015

D3511-041 WEARPLATE ASSEMBLY PARTS LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3511-041	WEARPLATE ASSEMBLY
1	D3511-1	WEARPLATE
8	D3503-1	CUP

NO. 34220
 WORK ORDER
 WITHOUT NOTICE
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 ENGINEERING
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 SHOP COPY

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A	06.04.04	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	JH	APPROVED
DATE	06.04.04	
DART	DART AEROSPACE LTD.	
DRAWING NO.	D3511	REV. A
TITLE	WEARPLATE	SHEET 1 OF 1
		SCALE NTS

RELEASED

06 04 25